

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021896**Date Inspected:** 10-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #16

Flux Cored Arc Welding (FCAW)

Weld joint 86, Located on Crash Barrier W5-SB42-001. Welder is identified as 201905. ZPMC Quality Control Inspector (QC) is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Bay #19

During a random observation this QA inspector observed the following component for the Orthotropic Bridge Girder (OBG) in Bay 19;

Suspender Bracket SB 106W

This QA observed that ZPMC was performing Gouging work on the above mentioned components during the time, this QA inspectors was present.

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Bay #14

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Weld joint 105, Located on Lift 14E, Floor beam FB 4676G IN P.P 126 mtr., SEG 3019Q-001. Welder is identified as 201087. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-TC-U4B-FCM-1.

Weld joint 002, Located on Lift 14E, Floor beam FB 3292 to Side plate SEG 3019C. Welder is identified as 066163. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-TC-U4B-FCM-1.

Flux Cored Arc Welding (FCAW)

Weld joint 035, Located on Lift 13, Edge plate EP 3027 to X4676G, SEG 3019AG. Welder is identified as 066733.

ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB

Weld joint 49, 50, Located on Bottom plate to stiffener plate, SEG 3019R. Welder is identified as 066763. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB

Weld joint 003, Located on Bottom plate to stiffener plate, SEG 3019U. Welder is identified as 066418. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevent Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By: Baskar,Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer